

SPLIT - 1

Work Order ID 71898 - 2



Wednesday, July 13, 2011 11:14:25 AM

Item ID: D4294-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 7/14/2011

Start Qty: 4.00



Required Date: 7/28/2011

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-07-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4294

C

100



Bandsaw

BAND SAW

0.00

Memo

0.00

*end 10/08/31*

*6*

*8*

Jeaspa Bandsaw

Cut Blank to 7.125"

Batch: 118201

\*\*\*\*GRAIN ALONG 4\*\*\*\*

110



HAAS I

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

Memo

1-Machine per folio FB008

DWG REV: *C*

FOLIO REV: *C*

*SA*

*11/8/31*

*4*

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

# Work Order ID 71898

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Page 2

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

121



Mill Conv

Conventional Milling Machine

Memo

DRILL & TAP FOR HELICOIL AS PER DWG

0.00

0.00

122



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11/15/31

11/09/01

11/09/01

4

4

4



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Stop



Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*OK 11/09/01*

*4 0*

140

Chemical Conversion Coat per QSi005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*4X Ø m-f 11/09/06*

145

White Gloss(Ref:4.3.5.1) per QSi005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

*Start Time : 3:30*

*Finish Time : 4:00*

*Temp: 320 °F*

*4X Ø m-f 11/09/06*

*m1745*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Wednesday, July 13, 2011 11:14:25 AM

Page 4

Item ID: D4294-1

Accept

Revision ID:

Item Name: Fitting

Start Date: 7/14/2011

Start Qty: 4.00

Required Date: 7/28/2011

Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4 d M 11/09/07

151



Small Fab

Small Fab

Memo

INSTALL HELICOIL AS PER DWG

0.00

0.00

4 11/09/07 (4)

152



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/09/07

(4)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 71898

Wednesday, July 13, 2011 11:14:25 AM



Page 5

Item ID: D4294-1

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Revision ID:

Stop



Item Name: Fitting

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location:

ST470

0.00

Changer de Place

Memo

0.00

*[Handwritten signature]*

(4X)

SP 11-09-07

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/8 *[Handwritten signature]*

MF 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, July 13, 2011 11:14:23 AM

Page 1

Work Order ID: 71898

Parent Item: D4294-1

Parent Item Name: Fitting



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD  
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F1-10

Purchased

No

Each

84.0000



HELI COIL

Location

Loc Qty

Loc Code

ST305

84

116977

84

M7075T73B4.000x4.00  
0

Purchased

No

100

f

26.8665

0.6

2.526316



7075-T73 Bar 4.0 x 4.0

Location

Loc Qty

Loc Code

MAT

12.1255

→ 118201

12.1255

MAT005

14.741

116153

0.75

116324

7.95

116764

6

116867

0.041

*EP 11/08/31*  
*EP 11/09/07*

*3.6* *mk 11/08/31*



DART AEROSPACE LTD		Work Order: 71898
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/- .030	.250	/		Vein	
3.375	+/- .010	3.375	/		"	"
4.875	+/- .010	4.875	/		"	"
1.670	+/- .010	1.670	/		"	"
φ0.386	+0.006/-0.001	.386	/		"	"
φ0.266	+0.006/-0.001	.268	/		"	"
6.81	+/- .030	6.810	/		Vein	CNC-02
6.35	+/- .030	6.350	/		"	"
3.440	+/- .010	3.440	/		Vein	
1.46	+/- .030	1.457	/		"	"
4.968	+/- .010	4.967	/		"	"
φ0.875	+/- .010	.875	/		"	"
φ0.750	+/- .010	.751	/		"	"
0.332	+0.020/-0.010	.335	/		mic	SL-4
0.691	+/- .010	.690	/		"	"
8°	+/- 1/2°	8°	/		C-square	ML-CBB
1.405	+/- .010	1.400	/		Vein	RAZ 6
φ0.381	+0.000/-0.001	φ.381	/		mic	RAZ 6
1.125	+/- .010	1.117	/		Vein	RAZ 6
6.49	+/- .030	6.490	/		Vein	CNC-02
R0.13	+/- .030	.130	/		R-6	ref.
0.64	+/- .030	.635	/		Vein	
2.15	+/- .030	2.150	/		"	"

Measured by: <i>[Signature]</i>	Audited by: <i>B.A</i>	Preliminary Approval:		
Date: 11/08/31	Date: 11/08/31	Date:		
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

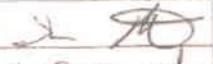
*10.04.15*



DART AEROSPACE LTD		Work Order: 71898
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1

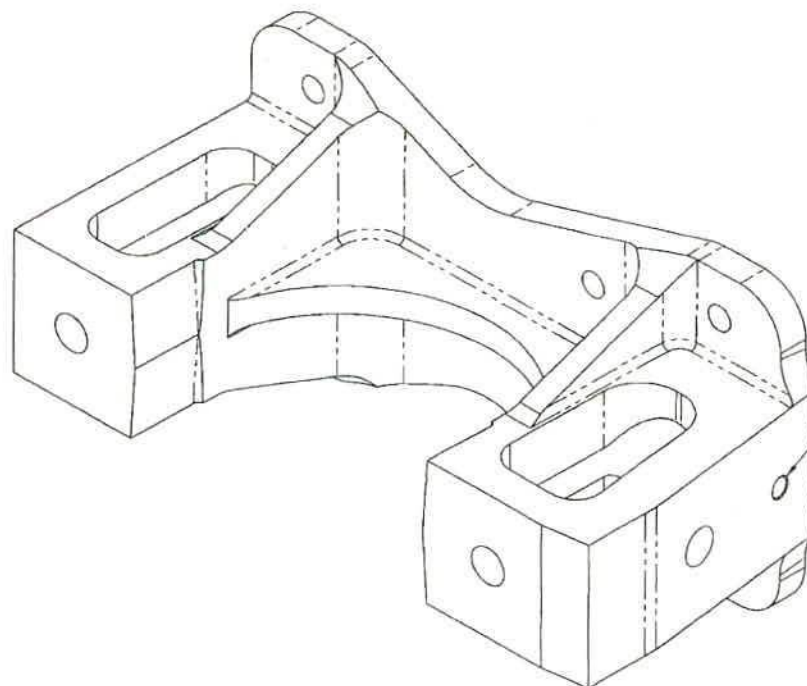
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	+/- .010	.062	/		Vein	2-3
0.305	+ .030 / - .010	.304	/		"	"
3.17	+/- .030	3.169	/		"	"
3.11	+/- .030	3.108	/		"	"
0.325	+/- .010	.327	/		"	"
0.780	+/- .010	.781	/		"	"
0.80	+/- .030	.795	/		"	"
1.560	+/- .010	1.560	/		"	"
0.500	+/- .010	.495	/		"	"
0.070	+/- .010	.072	/		H-G	"
0.39	+/- .030	.393	/		"	"
0.82	+/- .030	.800	/		"	"
0.500	+/- .010	.498	/		"	"
0.88	+/- .030	.871	/		"	"
0.764	+/- .010	.762	/		Vein	PA 216
0.201	+ .005 / - .001	0.201	/		Vein	"
0.320 x 100"	+ .001 / - .001	.320 x 100"	/		Vein	PA 216
3.44	+/- .030	3.440	/		"	"
2.450	+/- .010	2.450	/		"	"
2.04	+/- .030	2.045	/		"	"
1.528	+/- .010	1.523	/		"	"
0.300	+/- .010	.292	/		"	"
0.738	+/- .010	.737	/		"	"

Measured by: 	Audited by: J. A.	Preliminary Approval:
Date: 11-08-31 11/08/31	Date: 11/08/31	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



#71898

MS21209F1-10 HELICAL COIL, 1X  
REF

GRAIN  
DIRECTION

**D4294-1 FITTING**

RELEASED  
2011-02-01

**NOTES:**

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR  
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)  
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 8.1
- 7) WEIGHT: 1.55 lbs

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.780 WAS 0.76 (C6-2), 1.560 WAS 1.54 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.14		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4294</b>	REV. C
TITLE <b>FITTING (407 AFT)</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







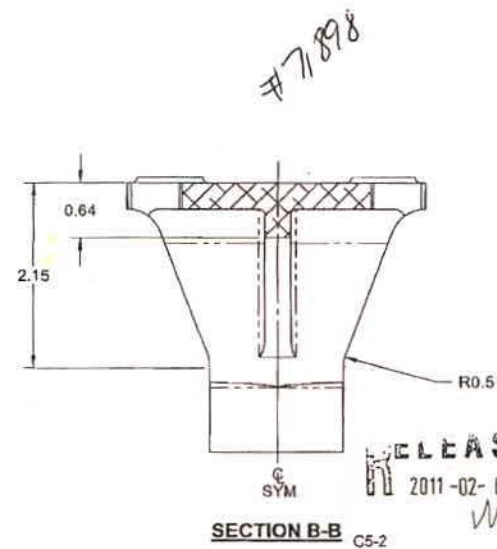
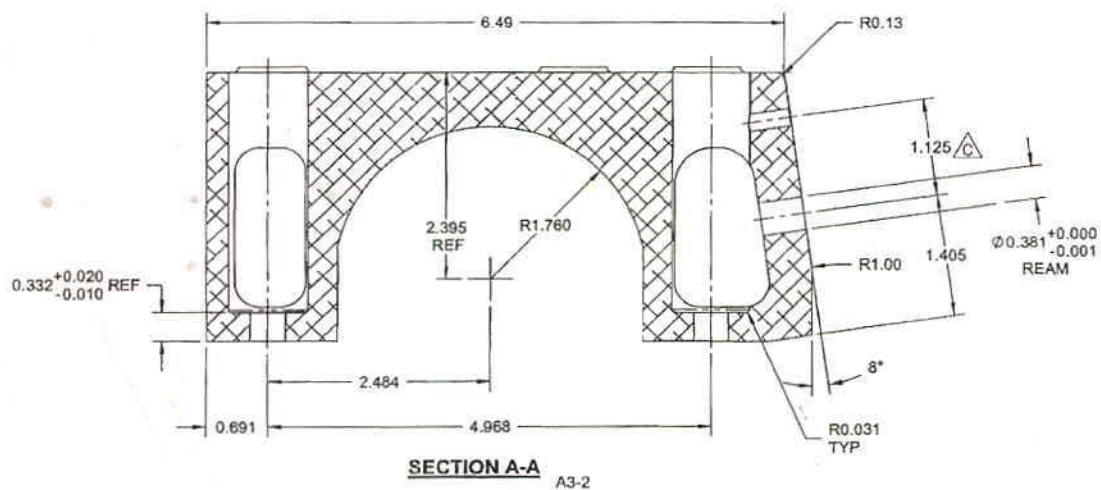
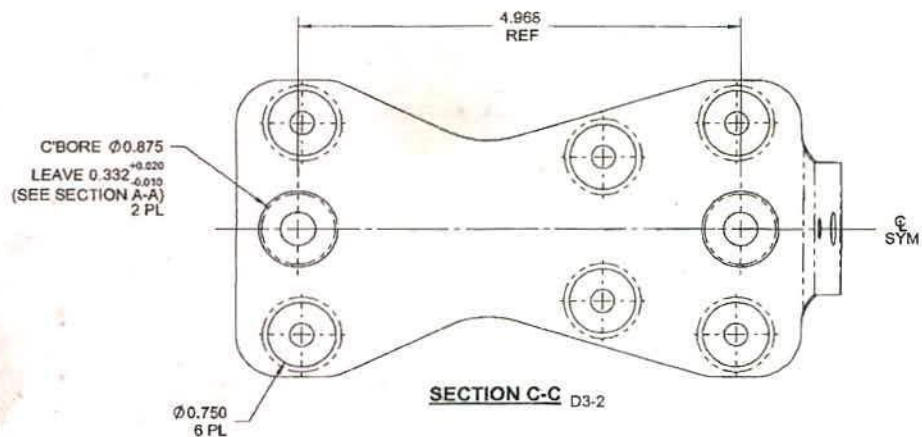
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4294	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>FITTING (407 AFT)</b>	NTS
DATE	11.01.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CIRCULATED AS SUPPLIED IN THE CONFIDENTIALITY THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71898
<b>Description:</b> FITTING		<b>Part Number:</b> D4294-1
<b>Inspection Dwg:</b> D4294 <b>Rev:</b> C		<b>Page 1 of 1</b>

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	+/- .010	.062	/		Vern	2-3
0.305	+ .030 / - .010	.304	/		"	"
3.17	+/- .030	3.169	/		"	"
3.11	+/- .030	3.108	/		"	"
0.325	+/- .010	.327	/		"	"
0.780	+/- .010	.781	/		"	"
0.80	+/- .030	.795	/		"	"
1.560	+/- .010	1.560	/		"	"
0.500	+/- .010	.495	/		"	"
0.070	+/- .010	.072	/		H+G	"
0.39	+/- .030	.393	/		"	"
0.82	+/- .030	.800	/		"	"
0.500	+/- .010	.498	/		"	"
0.88	+/- .030	.871	/		"	"
0.764	+/- .010	.762	/		" RA26 Vern	"
φ 0.201	+ .005 / - .001	φ .201	/		" "	" "
φ 0.320 x 100°	+ .006 / - .001 / +/ - 1/2°	1.320 x 100°	/		RA26	"
3.44	+/- .030	3.440	/		"	"
2.450	+/- .010	2.450	/		"	"
2.04	+/- .030	2.045	/		"	"
1.528	+/- .010	1.523	/		"	"
0.300	+/- .010	.292	/		"	"
0.738	+/- .010	.737	/		"	"

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 11-08-31 / 11/09/01	<b>Date:</b> 11/09/01	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71898
<b>Description:</b> FITTING		<b>Part Number:</b> D4294-1
<b>Inspection Dwg:</b> D4294 <b>Rev:</b> C		<b>Page</b> 2 <b>of</b> 2

### FIRST ARTICLE INSPECTION CHECKLIST

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3.375	+/- .010	3.375	/		"	"
4.875	+/- .010	4.875	/		"	"
1.670	+/- .010	1.670	/		"	"
φ0.386	+0.006 / -0.001	.386	/		"	"
φ0.266	+0.006 / -0.001	.268	/		"	"
6.81	+/- .030	6.810	/		Vern	CNC-02
6.35	+/- .030	6.350	/		"	"
3.440	+/- .010	3.440	/		Vern	
1.46	+/- .030	1.457	/		"	"
4.968	+/- .010	4.967	/		"	"
φ0.875	+/- .010	.875	/		"	"
φ0.750	+/- .010	.751	/		"	"
0.332	+0.020 / -0.010	.335	/		mic	HL-4
0.691	+/- .010	.690	/		"	"
8°	+/- 1/2°	8°	/		C-square	ML-CBB
1.405	+/- .010	1.403	/		Vern	RA26
φ0.381	+0.000 / -0.001	φ.381	/		mic	RA26
1.125	+/- .010	1.121	/		Vern	RA26
6.49	+/- .030	6.490	/		Vern	CNC-02
R0.13	+/- .030	.130	/		R-6	ref.
0.64	+/- .030	.635	/		Vern	
2.15	+/- .030	2.150	/		"	"

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11-08-31	<b>Date:</b> 11/09/01	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Signature]* 10.04.15